

28 MRS

Work Order ID 139025

139025

Page 1

Friday, November 13, 2015 11:16:32 AM

Item ID: D119-827-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Tail Rotor Pedal Lockout

Stop *NS2*

Start Date: 11/6/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: NOV 17 2015 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-827	D								
100	Document Control	0.00		DAS 6 9-89					MLS 16-02-26
100	DOCUMENT CONTROL								
DC	Memo	0.00			DAS 27 9-89				
Doc.Control -USB or Paperwork		Photocopy bluefile & type labels per PPP D119-827-011 CHG002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAR 08 2016

FEB 26 2016

DAS
6
DAS 9-89
28
9-89DAS
27
9-89

MAR 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																												
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Work Order ID 139025***139025***

Page 2

Item ID: D119-827-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Tail Rotor Pedal Lockout

Stop ***NS2***Start Date: 11/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-827-011 Location: _____								
		fg 122							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

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9-89
MAR 08 2016

ML5 MAR 08 2016

ML5 MAR 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, November 13, 2015 11:16:31 AM

Page 1

Work Order ID: 139025

139025

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 11/6/2015

Required Date: 11/13/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP
REV:B 13-01-09 REV B JLM VERIFIED:DD IPP REV:C
12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4704-041 *D4704-041* Expandable Pin Assembly		Manufactured	No			110	Each	7.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST120				7					
				136635				3					
				138379				4					
D4703-041 *D4703-041* Lock Pin Assembly		Manufactured	No			110	Each	0.0000	2	2			
										140/64x4			
D4710-1 *D4710-1* Spacer		Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST120				4					
				127249				4					
D4721-1 *D4721-1* Decal		Manufactured	No			110	Each	10.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST121				10					
				135997				10					

FEB 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Friday, November 13, 2015 11:16:31 AM

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Work Order ID: 139025

139025

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 11/6/2015

Required Date: 11/13/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-11A Purchased No 110 Each 132.0000 ****** 2 2 **DAS 6 9-89**

AN4-11A
BOLT

Location	Loc Qty	Loc Code
FG	20	
120731	20	
ST325A	112	
M128362	12	
M133234	100	

MS14144L4 Purchased No 110 Each 18.0000 ****** 2 2 **DAS 6 9-89**

MS14144L4
Nut

Location	Loc Qty	Loc Code
ST316	18	
m132680	18	

MS24665-153 Purchased No 110 Each 73.0000 ****** 2 2 **DAS 6 9-89**

MS24665-153
Cotter Pin

Location	Loc Qty	Loc Code
ST289	73	
107139	73	

NAS1149D0416J Purchased No 110 Each 4,561.000 ****** 2 2 **DAS 6 9-89**

NAS1149D0416J
WASHER

Location	Loc Qty	Loc Code
GA	347	
m131511	347	
ST260a	1992	
m131511	1992	
ST270	2222	
m131511	2222	

FEB 26 2016 **DAS 6 9-89**

Friday, November 13, 2015 11:16:32 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Work Order update only ☐

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																			
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Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition			Completed By																	
					Lead hand / Supervisor Approval Verification																	
					QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : _____																						

Picklist Print

Friday, November 13, 2015 11:16:32 AM

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Work Order ID: 139025

139025

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 11/6/2015

Required Date: 11/13/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

4,838.000

8

8

NAS1149D0463J

WASHER

**

134039

DAS
6
9-89

Location

Loc Qty

Loc Code

GA	626
M129390	41
M132035	585
ST260a	1500
M133316	1500
ST263	1270
M133284	1270
ST269	1442
M129682	47
M130799	371
M132317	101
M132677	888
M133077	35

DAS
28
9-89

DAS
27
9-89

NAS6604D16

Purchased

No

110

Each

35.0000

2

2

NAS6604D16

Bolt

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST262	35
m131616	35

SL2

2

FEB 26 2016

DAS
28
9-89

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

67.7 WEIGHT AND BALANCE

The following is the net increase associated with the D119-827-011 Kit.

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 Tail Rotor Pedal Lockout	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg

67.8 PARTS LIST

-011	Part Number	Description
X	D119-827-011	TAIL ROTOR PEDAL LOCKOUT
1	D4704-041	EXPANDABLE PIN ASSY
2	D4703-041	LOCKOUT PIN ASSY
1	D4710-1	SPACER
1	D4721-1	DECAL
2	AN4-11A	BOLT
2	MS14144L4	NUT
2	MS24665-153	COTTER PIN
2	NAS1149D0416J	WASHER
8	NAS1149D0463J	WASHER
2	NAS6604D16	BOLT

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